



Dart Aerospace Ltd.  
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**D206-642-512**  
**Job Sheet 201407**



**Part No:** D206-642-512

**Job Qty:** 1 pcs

**Part Name:** Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 10/3/19

**Job Tracking No:**

**Created By:** Marie Lajeunesse

**Due Date:** 10/10/19

**Description:** SIOP

**Type:** Stock

**Note:** DWG REV Q SHEETS 33-34 IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM IPP Rev:C 07-02-23  
As per IIN D206-642 Rev K JLM IPP rev D 07.06.06 added K642-512 EC IPP Rev:E 07-12-05 ECN 1080p Rev  
L DD verified by: IPP REV:F 13.09.06 CHG005/ ECN13-634 DD VERF:JLM IPP REV:G 14.04.28 AS PER  
ECN14-520 DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty   | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off |
|----------|------------------------|-------|------------|-------------|--------------|------------|-----------------------|-----------|----------|
|          |                        |       |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |          |
| 110      | Packaging 1 - Pick Kit | 1 pcs | 10/10/19   | 10/10/19    | 0.00         | 0.00       | Packaging 1 - 1       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 2       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 3       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 4       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 5       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 6       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 7       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 8       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 9       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 10      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 11      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 12      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 13      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 14      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 15      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 16      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 17      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 18      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 19      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 20      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 21      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 22      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 23      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 24      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 25      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 26      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 27      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 28      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 29      |           |          |



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**Container No:** S227754



**Part:** D206-642-512

**Job No:** 201407

**Serial No/Batch:** S227754

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:** FAA STC SA00475SE 18/10/17, FAA STC SH98-

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|                                 |       |          |           |                        |                   |
|---------------------------------|-------|----------|-----------|------------------------|-------------------|
| 120 QC 4                        | 1 pcs | 10/10/19 | 0.00 0.00 | Packaging 1 - 30       |                   |
|                                 |       |          |           | Packaging 1 - 31       |                   |
|                                 |       |          |           | Packaging 1 - 32       |                   |
|                                 |       |          |           | Packaging 1 - 33       |                   |
|                                 |       |          |           | Packaging 1 - 34       |                   |
|                                 |       |          |           | Packaging 1 - 35       |                   |
|                                 |       |          |           | Packaging 1 - 36       |                   |
|                                 |       |          |           | QC 4 - 28              |                   |
|                                 |       |          |           | QC 4 - 58              |                   |
|                                 |       |          |           | QC 4 - 69              |                   |
|                                 |       |          |           | QC 4 - 9               |                   |
|                                 |       |          |           | QC 4 - 46              |                   |
|                                 |       |          |           | QC 4 - 68              |                   |
|                                 |       |          |           | QC 4 - 72              |                   |
| 130 Packaging 3-1 - Stock - B4B | 1 pcs | 10/10/19 | 0.00 0.00 | QC 4 - 74              | DAS<br>78<br>9-89 |
|                                 |       |          |           | QC 4 - 75              |                   |
|                                 |       |          |           | QC 4 - 78              |                   |
|                                 |       |          |           | Packaging 3 - 1 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 2 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 3 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 4 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 5 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 6 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 7 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 8 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 9 - B4B  |                   |
|                                 |       |          |           | Packaging 3 - 10 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 11 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 12 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 13 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 14 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 15 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 16 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 17 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 18 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 19 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 20 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 21 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 22 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 23 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 24 - B4B | DAS<br>78<br>9-89 |
|                                 |       |          |           | Packaging 3 - 25 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 26 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 27 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 28 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 29 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 30 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 31 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 32 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 33 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 34 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 35 - B4B |                   |
|                                 |       |          |           | Packaging 3 - 36 - B4B |                   |
| 135 DC - 1 - B4B                | 1 pcs | 10/10/19 | 0.00 0.00 | DC - 1 - B4B           |                   |
| 140 QC 21 - FG                  | 1 pcs | 10/10/19 | 0.00 0.00 | DC - 2 - B4B           | OCT 2 9 2019      |
|                                 |       |          |           | QC 21 - FG - 21        |                   |
|                                 |       |          |           | QC 21 - FG - 70        |                   |
|                                 |       |          |           | QC 21 - SA - 53        | OCT 2 9 2019      |
|                                 |       |          |           | Broussard              | DAS<br>70<br>9-89 |

Part Op 110 - (Pick Kit)

Descriptions: 120 - (QC4- 100% Inspect kits for completeness)

130 - Identify and pack for shipping as per PPP D206-642-512

135 - (Document Control) Photocopy bluefile and create labels per PPP D206-642-512 CHG006

140 - (QC21- Final Inspection - Work Order Release)

**Job BOM**

| Part / Item  | Component Name                                               | Quantity     | Operation                     | Container |
|--------------|--------------------------------------------------------------|--------------|-------------------------------|-----------|
| D206-642-541 | Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag | 1 pcs (1 ea) | 110-Packaging 1 -<br>Pick Kit | S216643.  |
| K642-512     | Saddle                                                       | 1 pcs (1 ea) | 110-Packaging 1 -<br>Pick Kit | S222778   |

**Job Allocations**

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 110-Packaging 1 - Pick Kit | D206-642-541   | 1        | 7         | 0         |
|                            | K642-512       | 1        | 0         | 0         |

**Part Specifications**

Specifications could not be found.

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S216643x1

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

|                                  |             |                              |  |                                                                                                                                          |  |  |  |  |  |
|----------------------------------|-------------|------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|
| Job: _____                       |             | <b>DISPOSITION</b>           |  | <b>DEPARTMENT/PROCESS</b>                                                                                                                |  |  |  |  |  |
| Part No. _____                   |             | Rework<br>Scrap<br>Use-as-is |  | Cross tube    Skid-tube    Eng. (Non-AW)<br>Small Fab    Machining    Prod. Eng. Coord.<br>Finishing    Large Fab    Rec/Store/Packaging |  |  |  |  |  |
| Date :                           | Sequence #: | QTY Affected :               |  | MRB (QS04Z)                                                                                                                              |  |  |  |  |  |
| Description Work Order Deviation |             | Disposition                  |  |                                                                                                                                          |  |  |  |  |  |
|                                  |             |                              |  |                                                                                                                                          |  |  |  |  |  |
|                                  |             | Completed By                 |  |                                                                                                                                          |  |  |  |  |  |
|                                  |             | Lead hand / Supervisor       |  |                                                                                                                                          |  |  |  |  |  |
|                                  |             | QC / QA Coordinator          |  |                                                                                                                                          |  |  |  |  |  |

| Root Cause               |                       | FAULT CATEGORY           |                              |                          |                                 |                          |                    |                          |                   |                          |  |
|--------------------------|-----------------------|--------------------------|------------------------------|--------------------------|---------------------------------|--------------------------|--------------------|--------------------------|-------------------|--------------------------|--|
| <input type="checkbox"/> | Operator              | <input type="checkbox"/> | Pressure/Forced              | <input type="checkbox"/> | Contamination                   | <input type="checkbox"/> | Power Loss/Surge   | <input type="checkbox"/> | Positioned Wrong  | <input type="checkbox"/> |  |
| <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> | Bending                      | <input type="checkbox"/> | Misaligned/off center           | <input type="checkbox"/> | Folio/Program      | <input type="checkbox"/> | Outside Tolerance | <input type="checkbox"/> |  |
| <input type="checkbox"/> | Equip/Tooling         | <input type="checkbox"/> | Crushing                     | <input type="checkbox"/> | BOM/Route                       | <input type="checkbox"/> | Grain Direction    | <input type="checkbox"/> | Drawing           | <input type="checkbox"/> |  |
| <input type="checkbox"/> | Handling/Preservation | <input type="checkbox"/> | Cracks                       | <input type="checkbox"/> | Broken/Damage/Defect            | <input type="checkbox"/> | Weld               | <input type="checkbox"/> | Finish            | <input type="checkbox"/> |  |
| <input type="checkbox"/> | Material              | <input type="checkbox"/> | Crimp/Kink/Ripple/Wave/Twist | <input type="checkbox"/> | Incomplete/Unclear Instructions | <input type="checkbox"/> | Wrong Stock Pulled | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> |  |
| <input type="checkbox"/> | Product Improvement   | <input type="checkbox"/> | Marks/Chatter                | <input type="checkbox"/> | Drill Holes                     | <input type="checkbox"/> | Out of Sequence    | <input type="checkbox"/> | Misread           | <input type="checkbox"/> |  |
| <input type="checkbox"/> | Process Improvement   | <input type="checkbox"/> | Mislabeled                   | <input type="checkbox"/> | Fit/Function                    | <input type="checkbox"/> | Off-set/Set-up     | <input type="checkbox"/> |                   | <input type="checkbox"/> |  |
| <input type="checkbox"/> | Human Factors         | Other/Details:           |                              |                          |                                 |                          |                    |                          |                   |                          |  |

## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

| ITEM | QTY<br>-511 | QTY<br>-515 | QTY<br>-516 | QTY<br>-541 | QTY<br>-557 | QTY<br>-549 | QTY<br>-551 | QTY<br>-013 | PART NUMBER             | DESCRIPTION                                                                 |
|------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------------------|-----------------------------------------------------------------------------|
|      | X           | X           |             |             |             |             |             |             | D206-642-511            | SKIDTUBE INSTALLATION, LH                                                   |
|      |             |             |             |             |             |             |             |             | D206-642-512            | SKIDTUBE INSTALLATION, RH                                                   |
|      |             |             | X           |             |             |             |             |             | D206-642-515            | SKIDTUBE INSTALLATION, LH                                                   |
|      |             |             |             | X           |             |             |             |             | D206-642-516            | SKIDTUBE INSTALLATION, RH                                                   |
|      | 1           |             |             |             | X           |             |             |             | D206-642-541            | SKIDTUBE                                                                    |
|      |             |             |             |             |             | X           |             |             | D206-642-557            | WEARSHOE KIT (REPLACES -547 KIT)                                            |
|      |             |             |             |             |             |             | X           |             | D206-642-549            | RUN-ON LANDING WEARPLATE KIT                                                |
|      |             |             | 1           | 1           |             |             |             | X           | D206-642-551            | SKIDTUBE                                                                    |
|      | 1           | 1           | 1           | 1           |             |             |             | X           | D206-648-013            | GROUND HANDLING KIT                                                         |
| 1    |             |             |             |             | 1           |             |             |             | D3274-041               | SKIDTUBE ASSEMBLY                                                           |
| 1    |             |             |             |             |             |             | 1           |             | D4362-041               | SKIDTUBE ASSEMBLY                                                           |
| 3    |             |             |             |             | 1           |             | 1           |             | D2646                   | * AFT CAP <sup>(1)</sup>                                                    |
| 4    |             |             |             |             | 2           |             | 2           |             | AN3C4A                  | * BOLT <sup>(1)</sup>                                                       |
| 5A   |             |             |             |             | 2           |             | 2           |             | NAS1149C0332R           | * WASHER <sup>(1)</sup> (OR AN960C10L)                                      |
| 5B   |             |             |             |             | 2           |             | 2           |             | D3672-1                 | * WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>                               |
| 6    | 1           |             | 1           |             |             |             |             |             | D2932-1                 | SADDLE, FWD OUT, LH                                                         |
| 6    |             | 1           |             | 1           |             |             |             |             | D2932-2                 | SADDLE, FWD OUT, RH                                                         |
| 7    | 1           |             | 1           |             |             |             |             |             | D2933-1                 | SADDLE, FWD IN, LH                                                          |
| 7    |             | 1           |             | 1           |             |             |             |             | D2933-2                 | SADDLE, FWD IN, RH                                                          |
| 8    | 1           |             | 1           |             |             |             |             |             | D2938-1                 | SADDLE, AFT OUT, LH                                                         |
| 8    |             | 1           |             | 1           |             |             |             |             | D2938-2                 | SADDLE, AFT OUT, RH                                                         |
| 9    | 1           |             | 1           |             |             |             |             |             | D2939-1                 | SADDLE, AFT IN, LH                                                          |
| 9    |             | 1           |             | 1           |             |             |             |             | D2939-2                 | SADDLE, AFT IN, RH                                                          |
| 10   | 8           | 8           | 8           | 8           |             |             |             |             | AN3C41A                 | BOLT                                                                        |
| 11   | 16          | 16          | 16          | 16          |             |             |             |             | D2652                   | BUSHING                                                                     |
| 12A  | 8           | 8           | 8           | 8           |             |             |             |             | MS21043-3               | NUT                                                                         |
| 12B  | 16          | 16          | 16          | 16          |             |             |             |             | D3672-7                 | WASHER (REPLACES NAS1515H5)                                                 |
| 13   | 4           | 4           | 4           | 4           |             |             |             |             | AN5C11A<br>(or AN5C12A) | * BOLT <sup>(2)</sup>                                                       |
| 14   | 4           | 4           | 4           | 4           |             |             |             |             | AN5C11A<br>(or AN5C13A) | * BOLT <sup>(2)</sup>                                                       |
| 15A  | 8           | 8           | 8           | 8           |             |             |             |             | NAS1149C0532R           | WASHER (OR AN960C516L)                                                      |
| 15B  | 8           | 8           | 8           | 8           |             |             |             |             | D3672-7                 | WASHER (REPLACES NAS1515H5L)                                                |
| 16   | 12          | 12          | 12          | 12          |             |             |             |             | AN4C6A                  | BOLT                                                                        |
| 17A  | 24          | 24          | 24          | 24          |             |             |             |             | D3672-3                 | WASHER (REPLACES NAS1515H4L)                                                |
| 17B  | 24          | 24          | 24          | 24          |             |             |             |             | NAS1149C0432R           | WASHER (OR AN960C416L)                                                      |
| 18   | 12          | 12          | 12          | 12          |             |             |             |             | MS21043-4               | NUT                                                                         |
| 20A  |             |             |             |             | 9           | 9           |             |             | D3537-1                 | * WEARPAD <sup>(1)</sup> (REPLACES D2648-3)                                 |
| 21A  |             |             |             |             | 1           | 1           |             |             | D3537-3                 | * WEARPAD <sup>(1)</sup> (REPLACES D3429-1)                                 |
| 22A  |             |             |             |             | 1           | 1           |             |             | D4956-15                | * WEARSHOE <sup>(1)</sup> (REPLACES D3535-15 + D3536-15)                    |
| 23A  |             |             |             |             | 1           | 1           |             |             | D4956-23                | * WEARSHOE <sup>(1)</sup> (REPLACES D3535-23 + D3536-23)                    |
| 24A  |             |             |             |             | 1           | 1           |             |             | D4956-39                | * WEARSHOE <sup>(1)</sup> (REPLACES D3535-39 + D3536-39)                    |
| 25A  |             |             |             |             | 1           | 1           |             |             | D4956-35                | * WEARSHOE <sup>(1)</sup> (REPLACES D3535-35 + D3536-35)                    |
| 26A  |             |             | 8           | 8           | 78          | 78          | 8           |             | AN3C4A                  | * BOLT <sup>(1)</sup>                                                       |
| 26B  |             |             | 8           | 8           | 78          | 78          | 8           |             | NAS1149C0332R           | * WASHER <sup>(1)</sup> (OR AN960C10L)                                      |
| 26C  |             |             | 8           | 8           | 78          |             | 8           |             | ALS7-1032-130           | * INSERT <sup>(1)</sup><br>(or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 30   | 1           | 1           | 1           | 1           |             |             |             |             | D3407-043               | TOW RING                                                                    |
| 32A  | 1           | 1           | 1           | 1           |             |             |             |             | D3456-1                 | WASHER                                                                      |
| 32B  | 2           | 2           | 2           | 2           |             |             |             |             | D3457-1                 | WASHER                                                                      |
| 33   | 1           | 1           | 1           | 1           |             |             |             |             | MS21043-4               | NUT                                                                         |
| 34   |             |             | 1           | 1           | 1           |             |             |             | AN4C5A                  | BOLT                                                                        |
| 35   |             |             | 1           | 1           | 1           |             |             |             | NAS1149C0463R           | WASHER (OR AN960C416)                                                       |
| 36   |             |             | 1           | 1           | 1           |             |             |             | D3413-1                 | RING                                                                        |
| 37   | 10          | 10          | 10          | 10          |             |             |             |             | D2712                   | SET SCREW                                                                   |
| 38   | 2           | 2           | 2           | 2           |             |             |             |             | D2934                   | SADDLE SPACER                                                               |
| 39   | 2           | 2           | 2           | 2           |             |             |             |             | D2935                   | SADDLE SPACER                                                               |

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Revision: Q

Date: 13.08.12

## Change Record

PAGE 1 OF 1

**Part Number:** D206-642-511/-512 (K642-511/-512 SADDLE KITS, INTERNAL)

**Description:** FLOAT SKIDTUBE , LH/RH

[illegible]